

Work Order ID 55735

January 29, 2010 8:26:30 AM

Page 1

Item ID: D2010-104

Accept

Setup Start

Revision ID:

Stop

Item Name: Mirror Arm 369/500

Start Date: 1/28/10 Start Qty: 6.00

Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-1-29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2010

Rev D

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch per Dwg. D2010-104 and Spec Control Dwg D2727
Identify as D2010-104

= 7 m. 10/02/17

6X

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Bend as per Dwg D2010 using bending Jig D2010-104T2
2- Deburr ends

= 7 m. 10/02/18

6X

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- flare before installing plug as per dwg D2010
2- Install D2057 plug as per Dwg D2010

= 7 m. 10/02/18

6X

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

8/6/2013



QC

Memo

0.00

Quality Control

140

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:15 AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 9:45 AM

= 1 Jd 10/02/24

(X6) 6

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BL 10-02-24

(6) 6

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Page 3

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Item Name: Mirror Arm 369/500

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Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 220

0.00



Packaging

Memo

0.00

Packaging

P 1/3/01 (6)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/02 1003/01/10

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 29, 2010 8:26:34 AM

Page 1

Work Order ID: 55735

Parent Item: D2010-104

Parent Item Name: Mirror Arm 369/500

Start Date: 1/28/10

Required Date: 2/08/10

Comments: IPP [A] 04.02.17 [] New issue [] KJ/JLM []
IPP Rev:B 08-05-27 as per ECN1195P DD verified by:EC
IPP Rev:C 08-06-20 rev.D as per dwg DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M304TR0.500W.049		Purchased	No			100	f	86.5100	9.4737			



304 RD Tube .500 x .049W

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	MAT	86.5099895	
	111814	86.5099895	

D2057

Manufactured No



Plug

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST006	63	
	34366	42	
	40048	21	

Loc Code

63.0000

6.0000

3X
3X

M-L
10/02/17

M-L
10/02/18

6X

Dart Aerospace Ltd

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NOTE: Date & initial all entries

8

7

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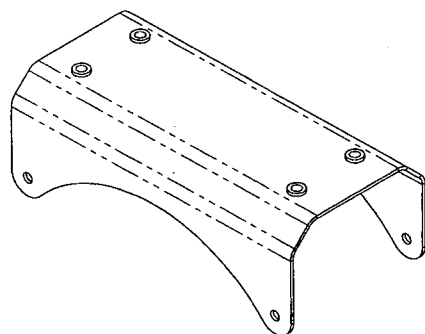
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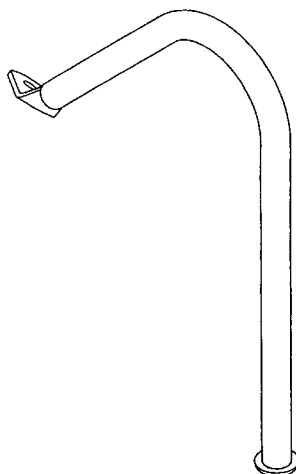
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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 55735

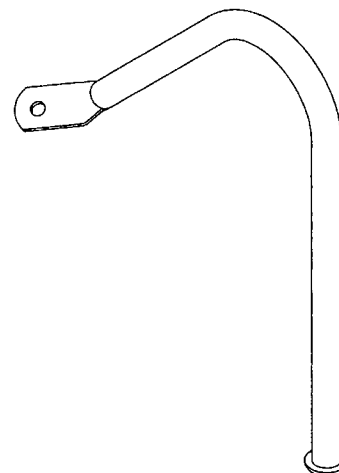
Bj10-1-29



D2010-101 MIRROR BRACKET



D2010-103 ARM



D2010-104 ARM

RELEASED
08.06.10

D	REDRAWN IN SOLIDWORKS; ADD D2010-1F FLAT PATTERN FOR D2010-101 (ZN B7-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN B1-3, B1-4); REASON: TUBING CRACKING DURING SERVICE	PH	08.06.10
C	1.83 WAS 2.00; 0.50 WAS 0.82	KE	97.10.31
B	7.90 WAS 10.90	JB	92.03.17
A	NEW ISSUE	JB	90.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	AD	DRAWING NO.	REV. D
MFG. APPR.	AD	D2010	SHEET 1 OF 4
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DE APPR.	AD	MIRROR BRACKET	NTS
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8

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4

3

2

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

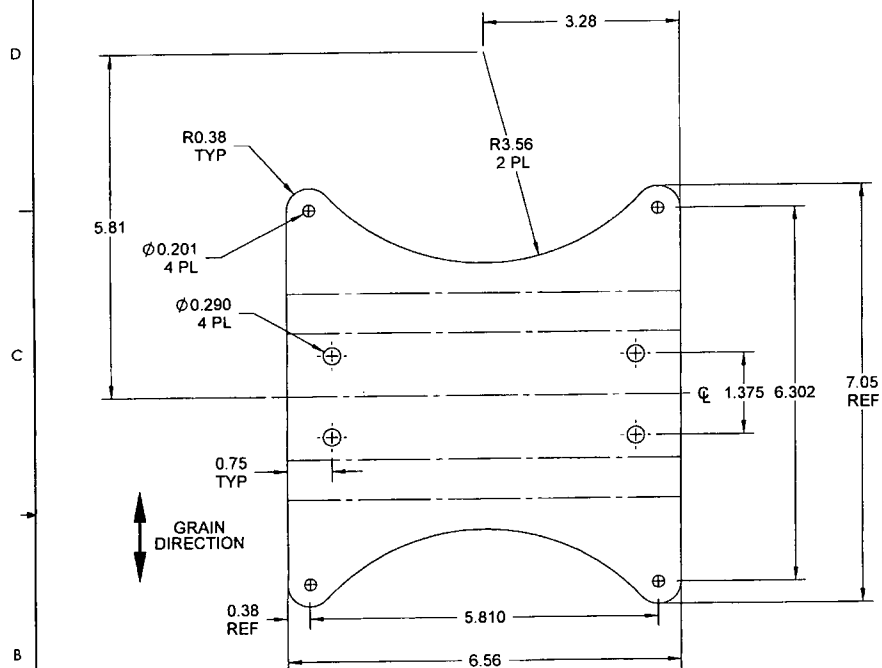
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

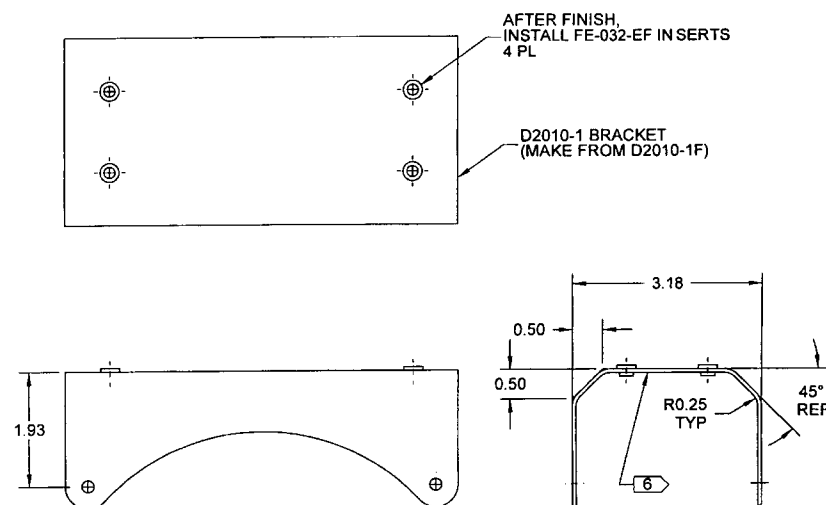
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -101	P/N	DESCRIPTION
X	D2010-101	MIRROR BRACKET
1	D2010-1	BRACKET
4	FE-032-EF	INSERT



D2010-1F FLAT PATTERN



D2010-101 MIRROR BRACKET

RELEASED
08-06-10/10

NOTES:

- 1) MATERIAL: D2010-1F: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-101" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: 0.23 lbs

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	PL	DRAWING NO. D2010	REV. D
MFG. APPR.	PL		SHEET 2 OF 4
APPROVED	PL	TITLE	SCALE
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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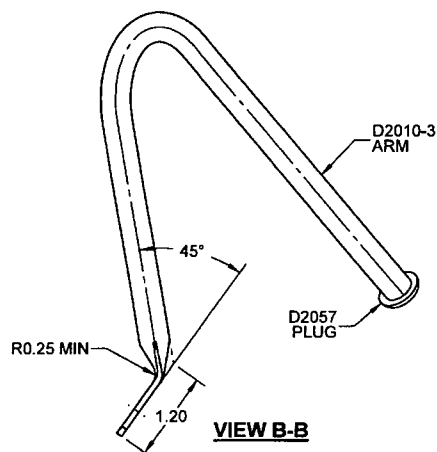
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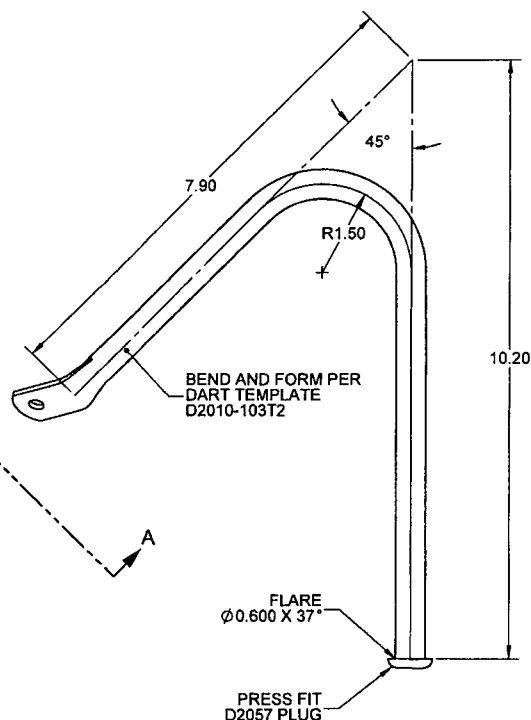
NOTE: Date & initial all entries

QTY -103	P/N	DESCRIPTION
X	D2010-103	ARM
1	D2010-3	ARM
1	D2057	PLUG

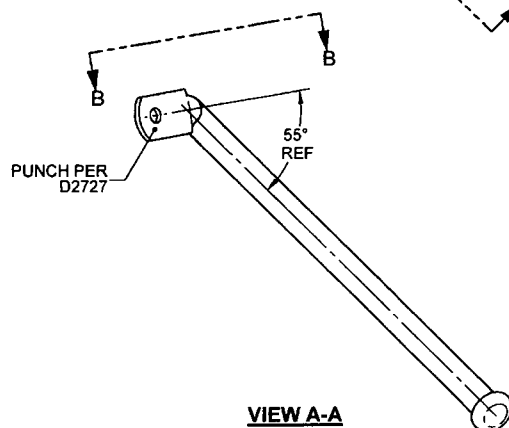
W/O 55735



VIEW B-B





D2010-103 ARM



VIEW A-A

RELEASED
03 06 1974

- NOTES:
- 1) MATERIAL: D2010-3: AISI 304/316 SS SEAMLESS ROUND TUBING, $\phi 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049) Δ
 - 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-103" USING WHITE FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34 lbs

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	JB	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	PH	D2010	SHEET 3 OF 4
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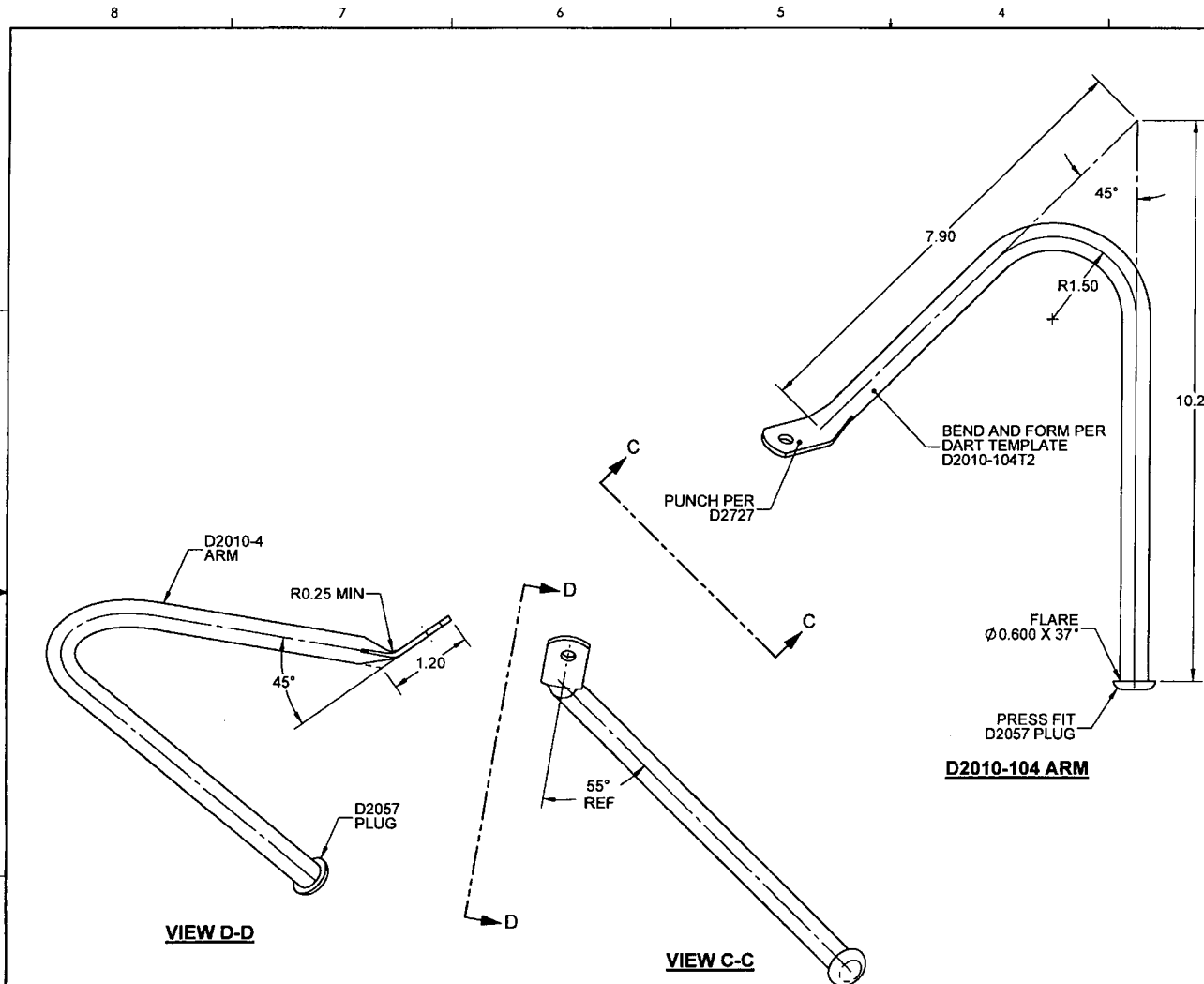
QTY -104	P/N	DESCRIPTION
X	D2010-104	ARM
1	D2010-4	ARM
1	D2057	PLUG

w/o 55735

RELEASED
08-06-10

- NOTES:
- 1) MATERIAL: D2010-4: AISI 304/316 SS SEAMLESS ROUND TUBING, $\phi 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049) Δ
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-104" USING WHITE FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34 lbs

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	JS	D2010	SHEET 4 OF 4
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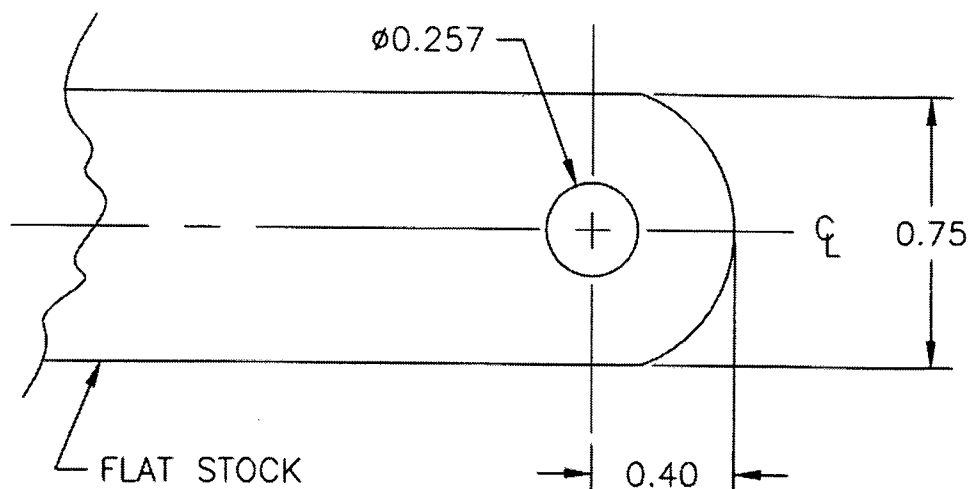
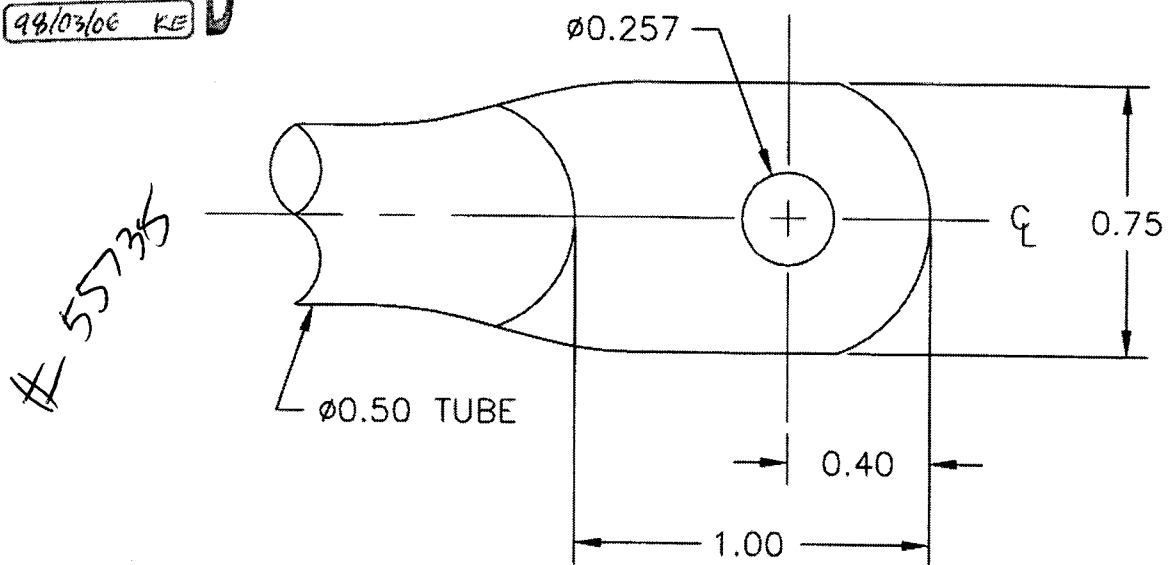
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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	#CP 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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